

Date: Monday, 12/01/2009 9:12:19 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD DOUBLER
 Job Number : 44598
 Estimate Number : 13150
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 38948
 Part Number : D37021
 Drawing Number : D3702 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 15/01/2009 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:ec

Additional Product

MININARY ISSUE



Job Number:



found in PDR
 ECN #09.502P

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.6556 sf(s)/Unit Total : 3.2781 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 110254 B 9-1-13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3702

Dwg Rev: PLE B 9-1-13

Prog Rev: LIM

2- Deburr if necessary B 9-1-13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

TO 090114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 9:12:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD DOUBLER

Job Number: 44598

Part Number: D37021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09.01.15

(5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

090114

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

079 96/18

EX SC

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/08

Job Completion



MF 09-01-15

POSITIVE RECALL
EFFECTIVE 09/01/12 AUTH
RELEASED DATE 09.06.05

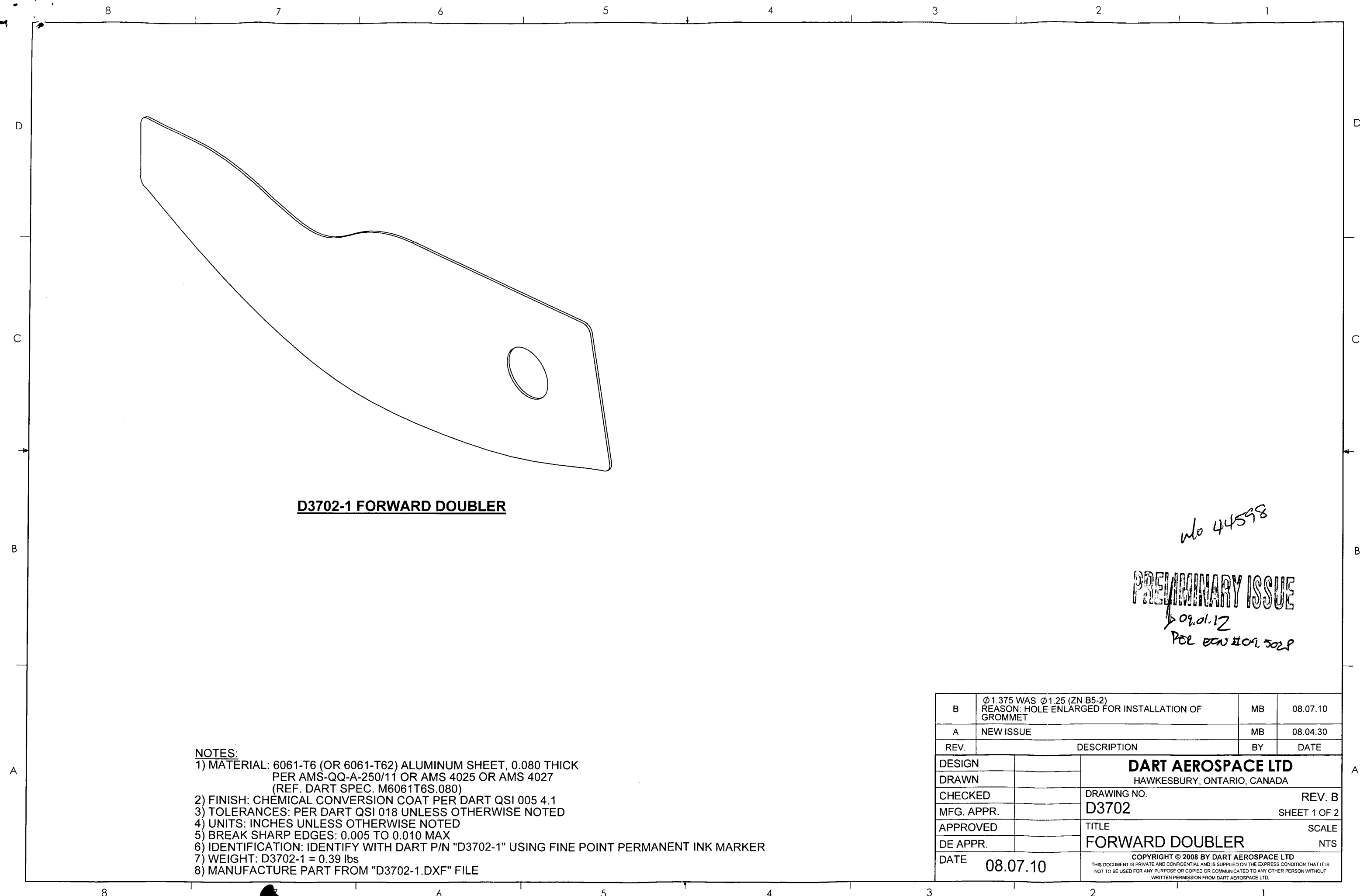
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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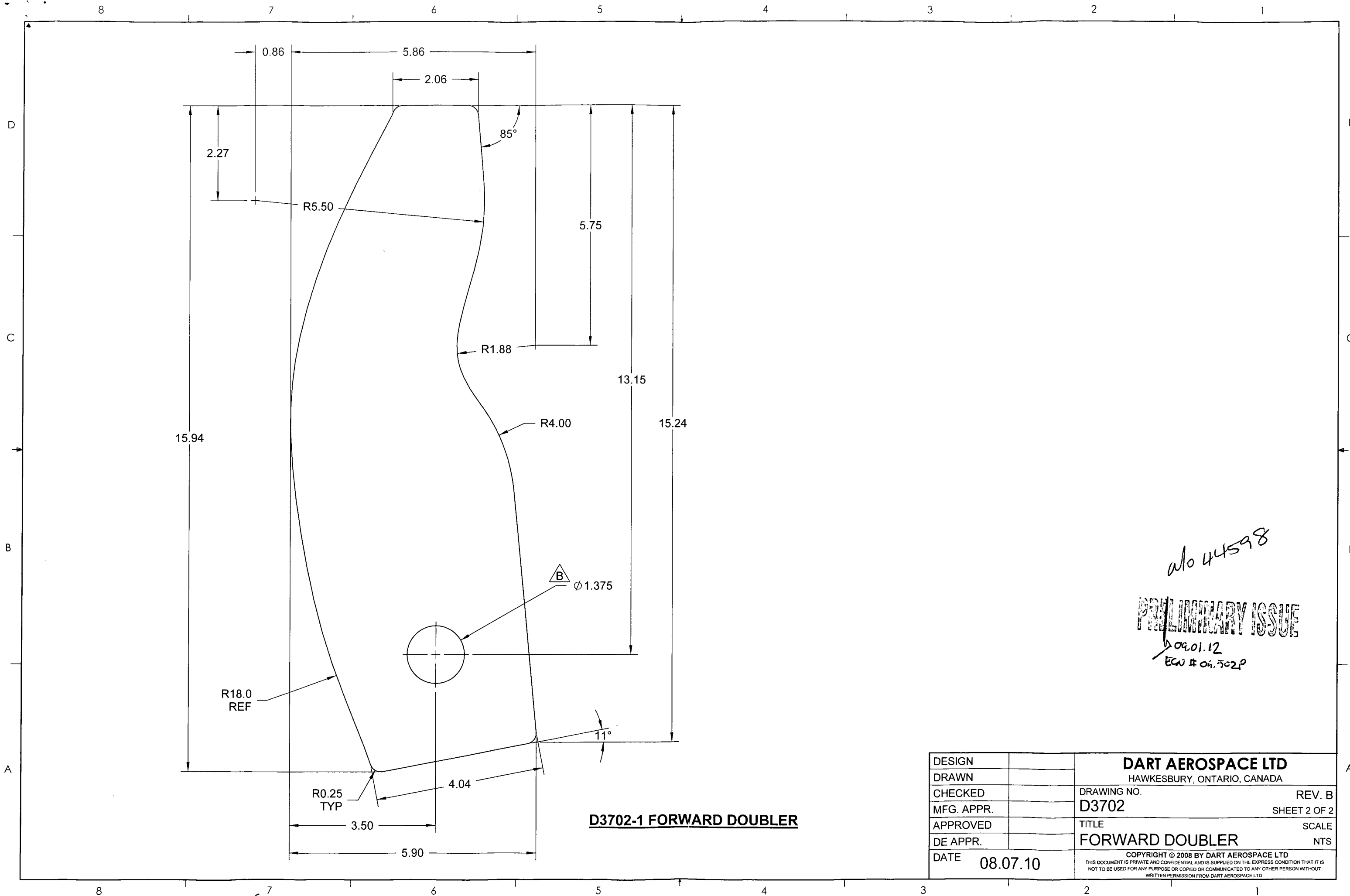


D3702-1 FORWARD DOUBLER

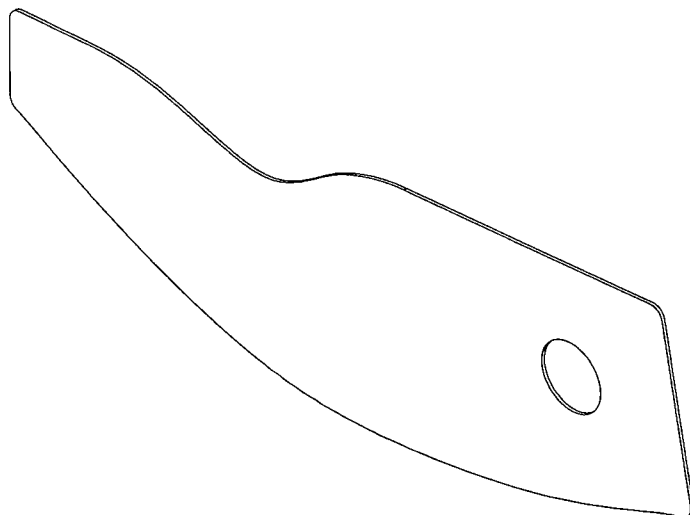
w/o 44598
PRELIMINARY ISSUE
09.01.12
Per spec #109.5029

- NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3702-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3702-1 = 0.39 lbs
8) MANUFACTURE PART FROM "D3702-1.DXF" FILE

B	Ø1.375 WAS Ø1.25 (ZN B5-2) REASON: HOLE ENLARGED FOR INSTALLATION OF GROMMET	MB	08.07.10
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3702	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FORWARD DOUBLER	NTS
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3702	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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D3702-1 FORWARD DOUBLER

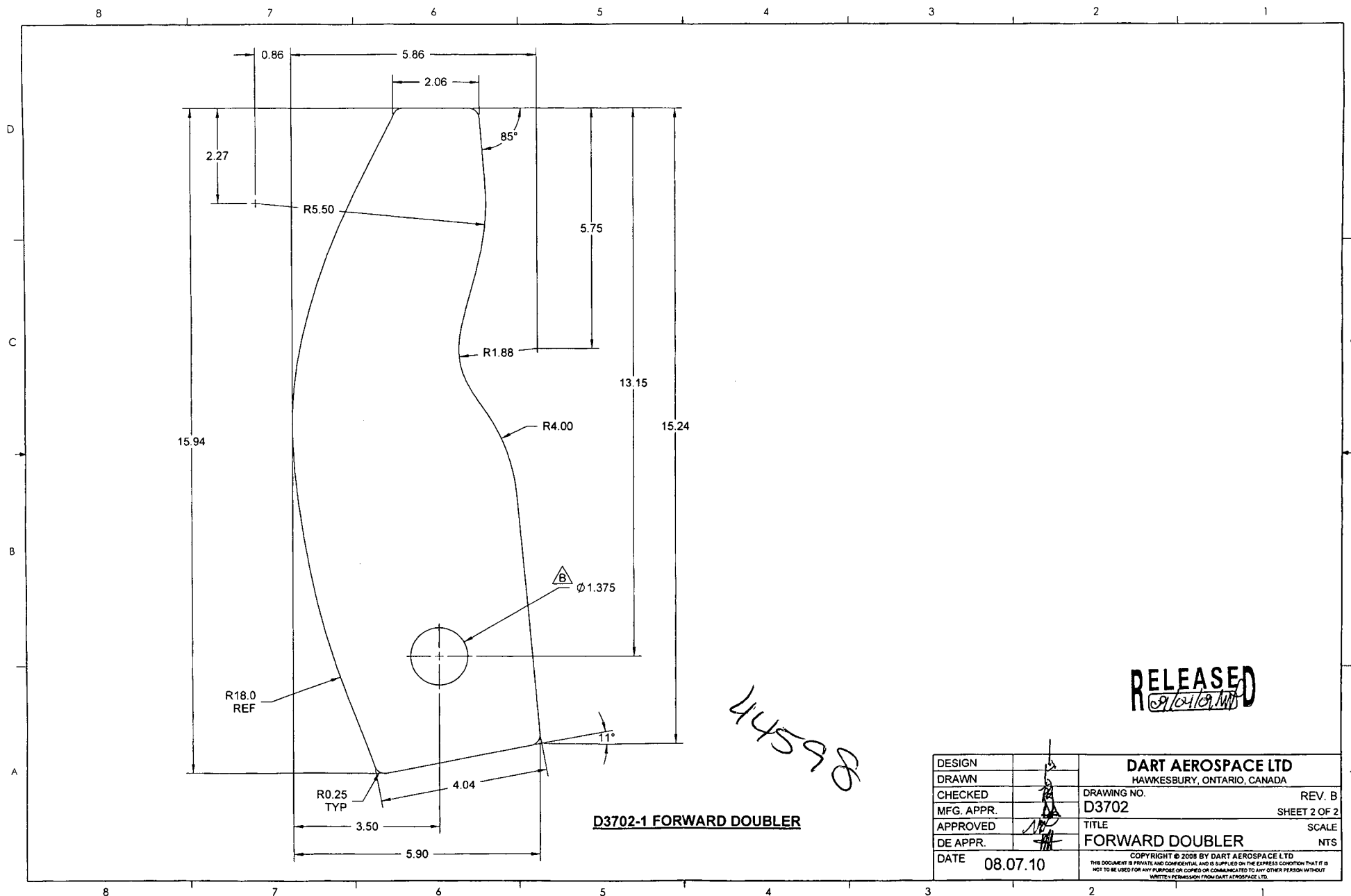
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44598

RELEASED
09/04/09 JHT

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RELEASED
 09/04/09 MTD

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